

Work Order ID 78940

78940

January-17-12 1:29:25 PM

Page 1

Item ID: D3140-05

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Door

Stop

NS2

Start Date: 17/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/01/17 Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3140	Rev F

100 0.00

100

Packaging

Memo 0.00

Packaging Pick kit to ship to Delastek

1 12/09/2017

110

QC4- 100% Inspect kits for completeness 0.00

110

QC

Quality Control

Memo 0.00

CZ 13/01/21

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

- Work Order ID 78940

78940

January-17-12 1:29:25 PM

Page 2

Item ID: D3140-05

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Door

Stop

NS2

Start Date: 17/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

Purchasing

Memo

0.00

CL 12/02/17 1

Purchasing

Issue P/O: 10439

Purchase Part Number: D3140-05

Supplier: Delastek

Ship kit and make as per dwg

Conformity Certificate and Process sheet required

130

Receive & Inspect for Damage & Mat'l Certs

0.00

130

Packaging

Memo

0.00

Packaging

1/3/13 ①

140

QC6- Inspect dimensions to drawing

0.00

140

QC

Quality Control

Memo

0.00

DAS
16
B(05/0)

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

Material cert attached to

wl 78942

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

January-17-12 1:29:25 PM

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Door

Stop

NS2

Start Date: 17/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date: _____

Run Start

NR1

QC:

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

150

Identify as per dwg & Stock Location: _____

150

Packaging

Packaging

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0 8 13.10.14

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Quality Control

Memo

0.00

A/RM 13/10/18

M/B-10-10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January-17-12 1:29:28 PM

Page 1 /1

Work Order ID: 78940

78940

Parent Item: D3140-05

D3140-05

Parent Item Name: Door

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3140-87	Manufactured	No			100	Each	0.0000	1	1	**			
----------	--------------	----	--	--	-----	------	--------	---	---	----	--	--	--

D3140-87

Doubler

D3140-95	Manufactured	No			100	Each	7.0000	3	3	**			
----------	--------------	----	--	--	-----	------	--------	---	---	----	--	--	--

D3140-95

Doubler

			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			ST028		7								
			52265		7								

D3140-97	Manufactured	No			100	Each	2.0000	1	1	**			
----------	--------------	----	--	--	-----	------	--------	---	---	----	--	--	--

D3140-97

Doubler

			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			CA		2								
			37773		2								

D3140-241	Manufactured	No			100	Each	0.0000	1	1	**			
-----------	--------------	----	--	--	-----	------	--------	---	---	----	--	--	--

D3140-241

Doubler

D3140-301	Manufactured	No			100	Each	0.0000	1	1	**			
-----------	--------------	----	--	--	-----	------	--------	---	---	----	--	--	--

D3140-301

Doubler

D3140-05 P

13/3/13 78940

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>4</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JLH</i>	APPROVED <i>TH</i>	DRAWING NO. D3140	
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED
06.11.13 *#*

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED DRAWING
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO. *78940 MLJ*
12/01/117

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
			1	X		D3140-09	DOUBLER ASSEMBLY
				1	X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
			1			D3140-71	PAD
				1		D3140-73	PAD
				1		D3140-75	PAD
				1		D3140-77	PAD
				1		D3140-79	PAD
					1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
					1	D3140-89	DOUBLER
				1		D3140-91	DOUBLER
					1	D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
			2	2		D3140-101	DOUBLER
			1			D3140-103	DOUBLER
				1		D3140-104	DOUBLER
				1		D3140-105	DOUBLER
					1	D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JLH</i>	APPROVED <i>CH</i>	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS



COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM



FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S



MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13



MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECCELL



ALL DIMENSIONS IN INCHES



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION



DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION



RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130



PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1

F
11/13/06

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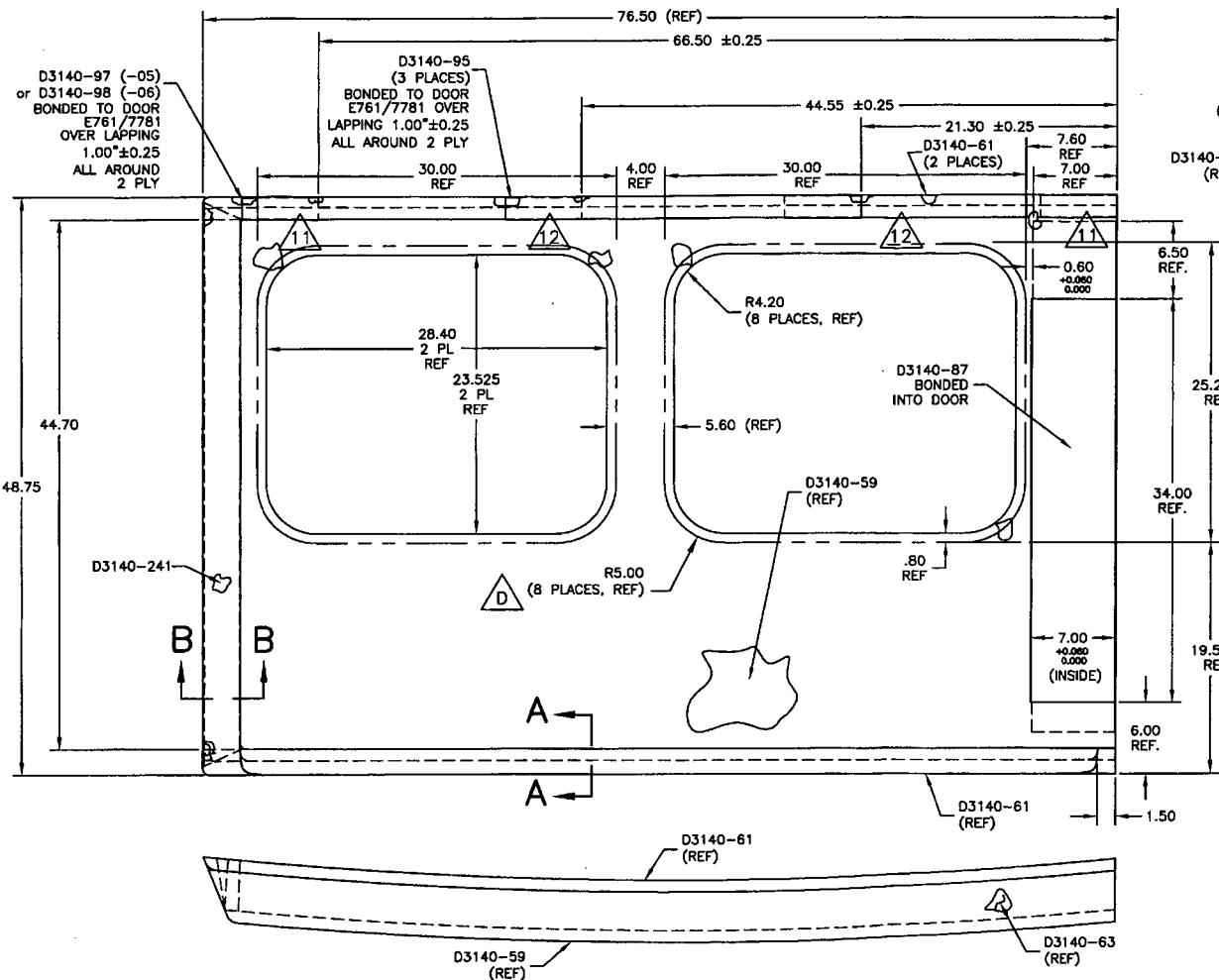
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78940



D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)



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IGN 4	DRAWN BY CB	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CKED SD	APPROVED SD	DRAWING NO. D3140	REV. F SHEET 3 OF 7
E		TITLE DOOR	SCALE NIT
10.06			

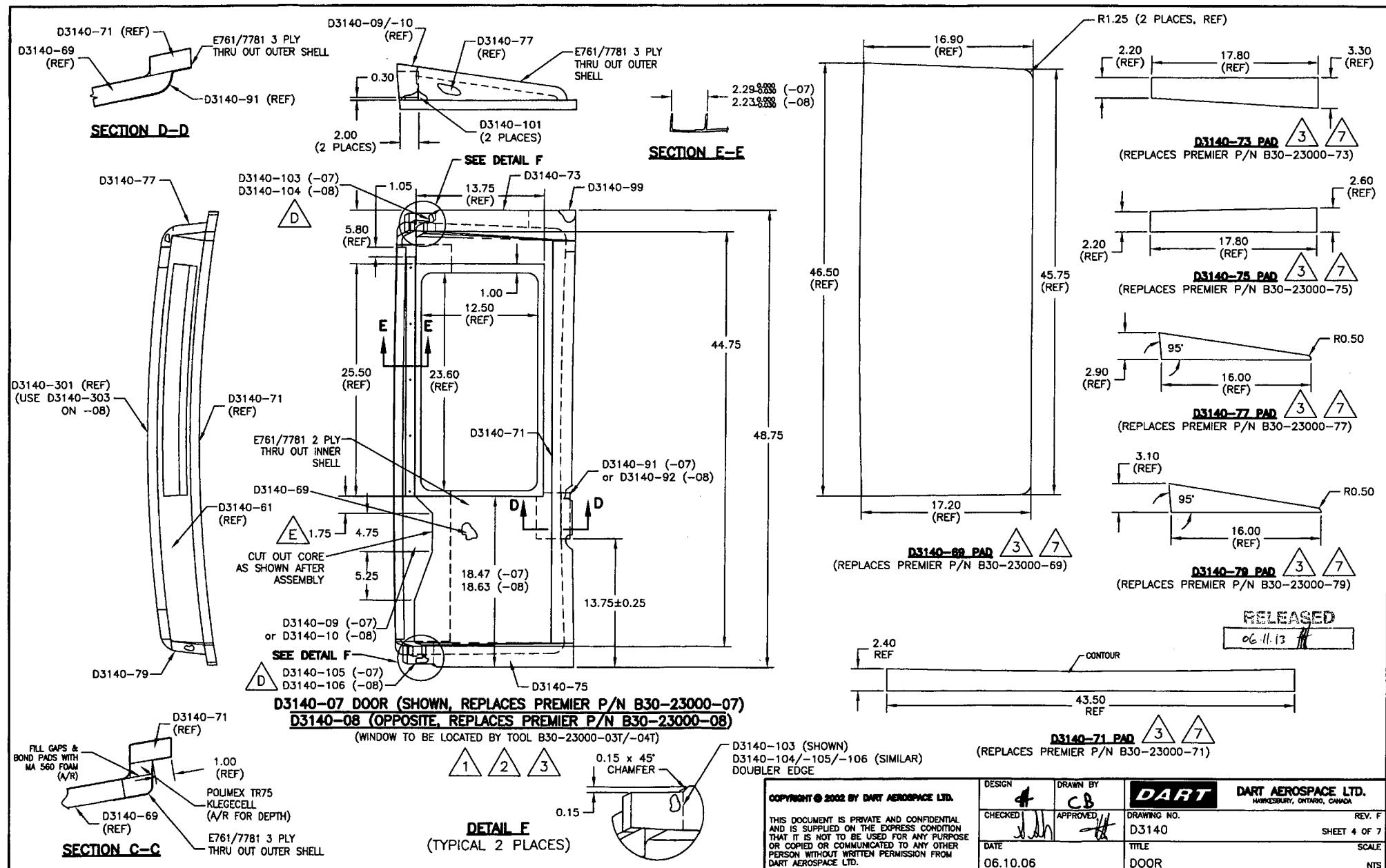
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NOTE: Date & initial all entries

78946



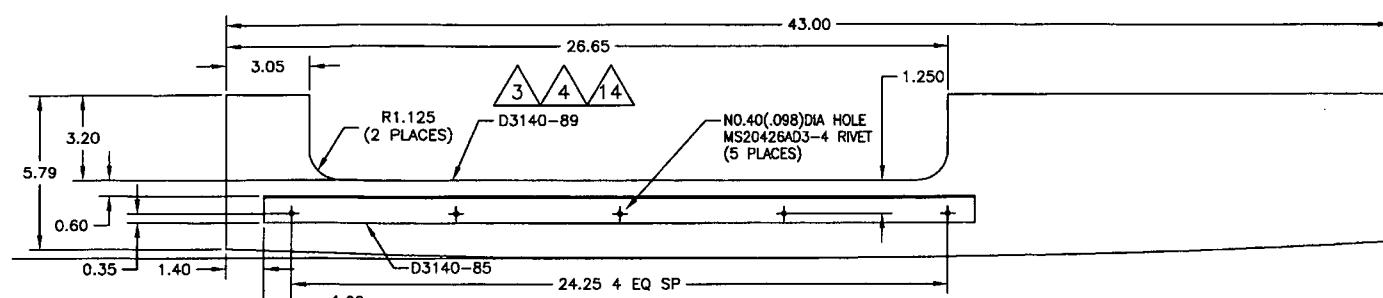
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

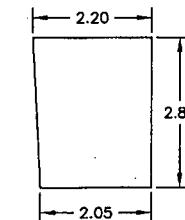
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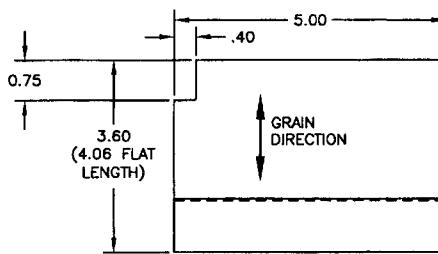
78940



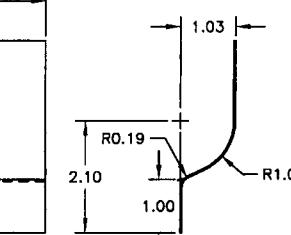
D3140-09 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-09)
D3140-10 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-10)



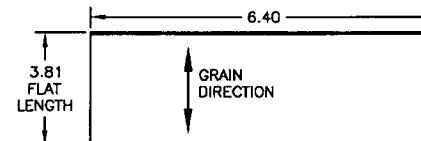
D3140-101 DOUBLER (REPLACES PREMIER P/N B30-23000-101)



D3140-91F DOUBLER
(USE TO MAKE D3140-91/-92 DOUBLERS)



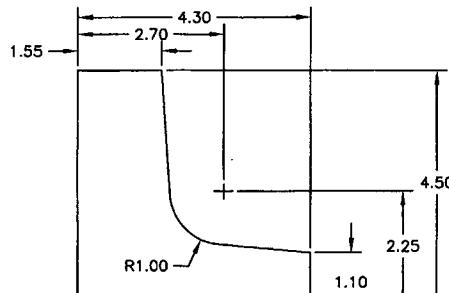
D3140-92 DOUBLER (REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



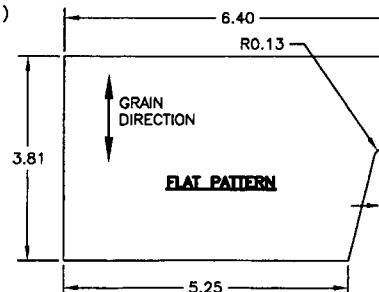
D3140-95 DOUBLER (REPLACES PREMIER P/N B30-23000-95)

RELEASED

06.11.13



D3140-99 DOUBLER (REPLACES PREMIER P/N B30-23000-99)



D3140-97 DOUBLER
(USE TO MAKE D3140-97/-98 DOUBLERS)

06.11.13

RELEASED

06.11.13

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWTHORPE, ONTARIO, CANADA
4	CB		
CHECKED	APPROVED		DRAWING NO. D3140
06.10.06		REV. F SHEET 5 OF 7 NTS	TITLE DOOR SCALE

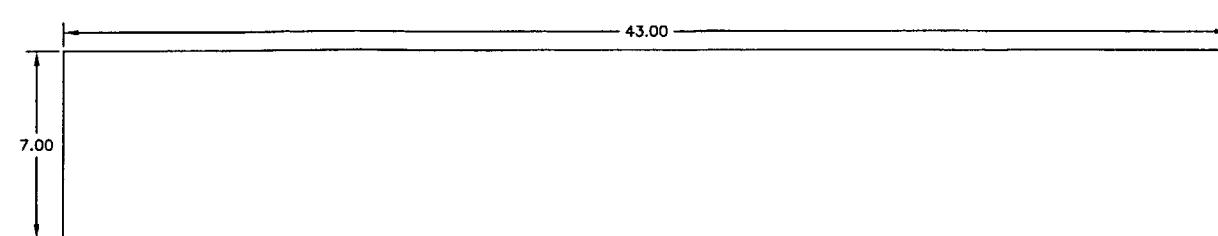
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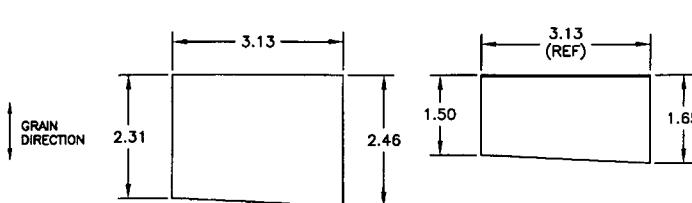
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78940



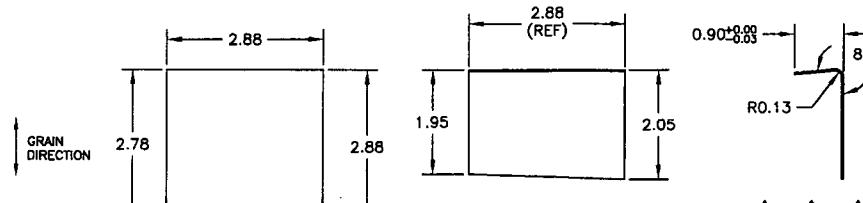
D3140-87 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-87)



D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

D3140-105 DOUBLER
D3140-106 OPPOSITE

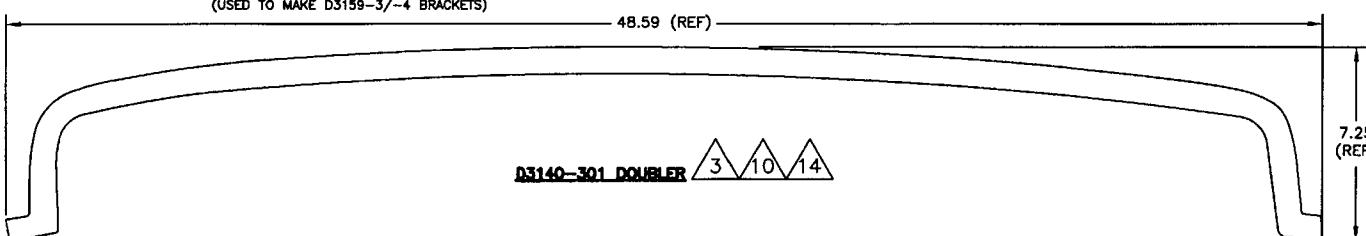
4 14 D



D3140-104 DOUBLER
D3140-103 OPPOSITE

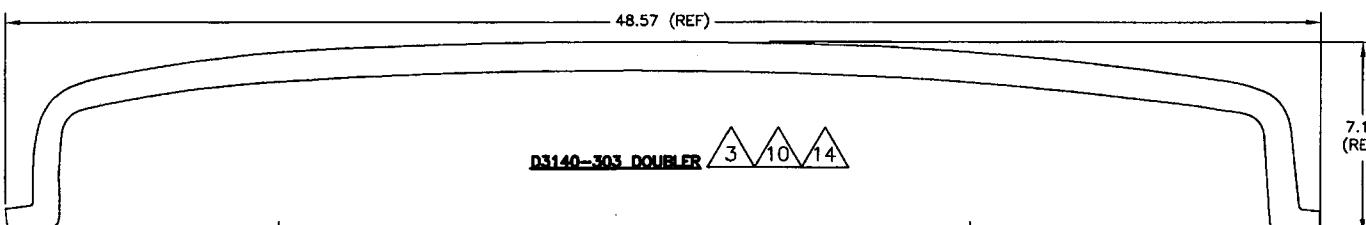
4 14 D F

D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

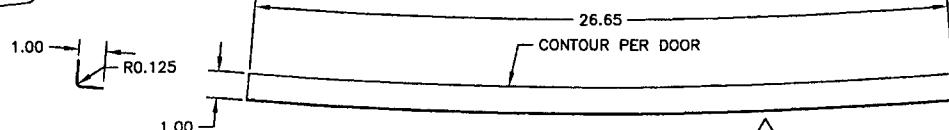


RELEASED
06.06.03

D3140-301 DOUBLER 3 10 14



D3140-303 DOUBLER 3 10 14



D3140-85 ANGLE 6
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	D3140	REV. F SHEET 8 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

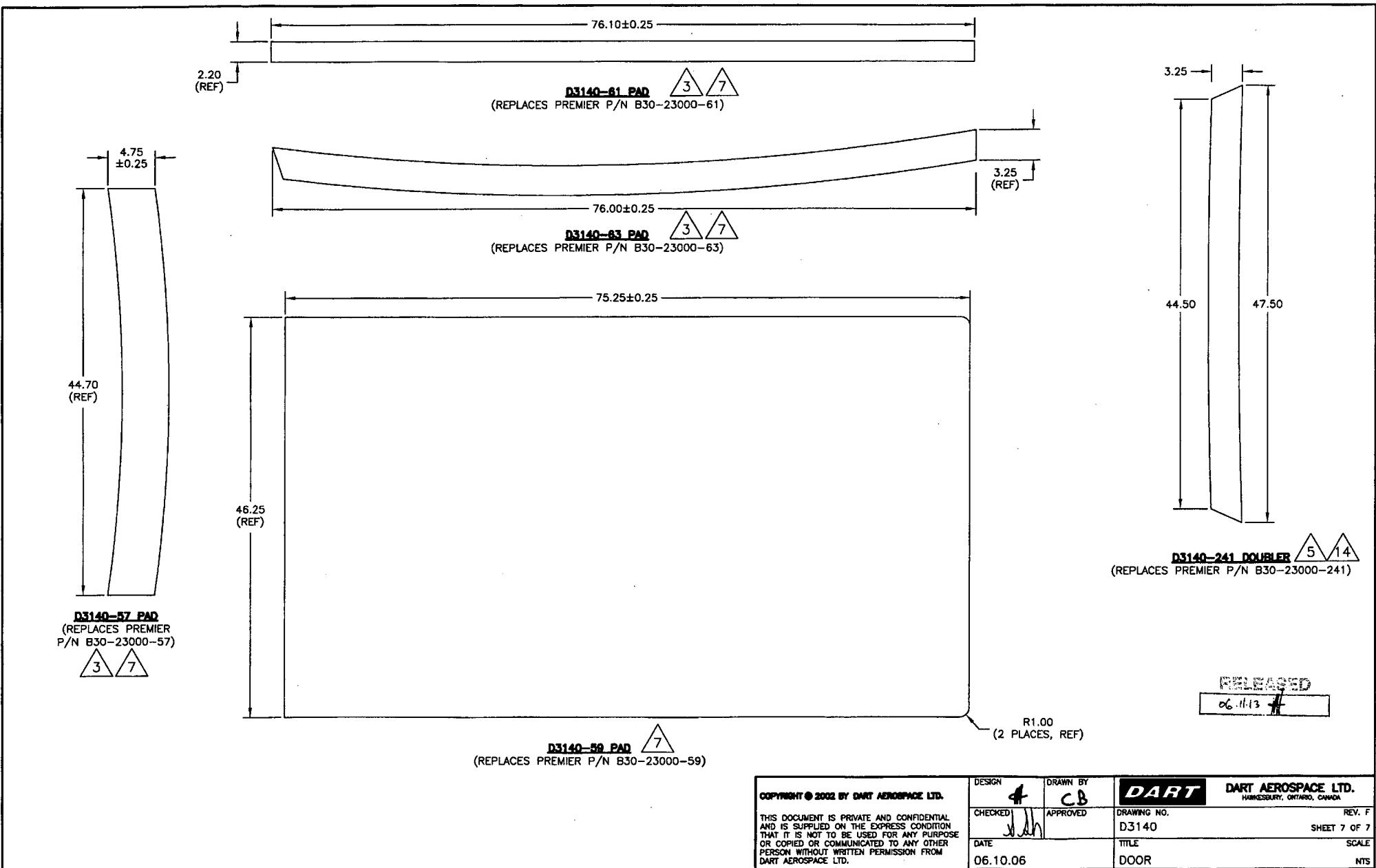
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78940



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16439

Purchase Order Date 3/14/12

PO Print Date 4/23/12

Page Number 1 of 2

Order From :
DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Contact Name	Buyer	Chantal Lavoie
Vendor Phone	Requisition Nbr	
Vendor Fax	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	USD
	FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
		Vendor Part Number					
1	D3140-05P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50
					✓ 13/3/13		
2	D3140-06P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50
3	D3140-07P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50
					✓ 14/3/13		
4	D3140-08P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50

		No substitution or deviation without consent. Certificate of Conformity or Material Certification required when applicable
Change Nbr:	3	Change Date: 4/23/12